

Work Order ID 58246

Sunday, May 02, 2010 1:13:20 PM



Page 1

Item ID: D4021-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Data Plate

Start Date: 5/3/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *10-5-2*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Shear

Memo

0.00

Shear

1-Cut as per dwg D4021

2- break sharp corner as per dwg D4021

3-Deburr as required

SAO 10-05-05

(3)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. 10/05/05

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

SB 10/05/05

(3)

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SAD 10/05/05

(3)

Quality Control

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

SAD 10-05-05

(3)

Packaging

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

Stop



Item Name: Data Plate

Start Date: 5/3/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06 *ff*

MF

10-5-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Sunday, May 02, 2010 1:13:20 PM

Page 1

Work Order ID: 58246



Parent Item: D4021-3



Parent Item Name: Data Plate

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
new part DD 09.12.03 verified by:EC
REV.A DD 10.02.22 verified by:EC
10.04.20 verified by:EC
IPP RevB:
IPP Rev:C as per dwg
IPP Rev:D as per dwg revB DD

Start Qty: 3.00

Required Qty: 3.00

M304S20GA

Purchased

No

100

sf

5.2675

0.1944



SAD

10-05-05

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT20

5.2675

112885

3.1363

113062

2.1312

3 X 0.1944 = 0.5832

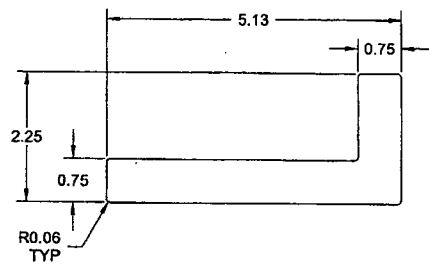
W/O:		WORK ORDER CHANGES						
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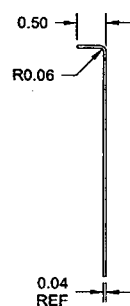
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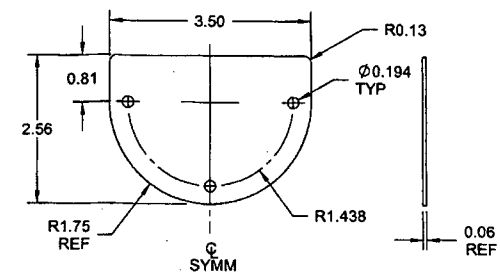
NOTE: Date & initial all entries



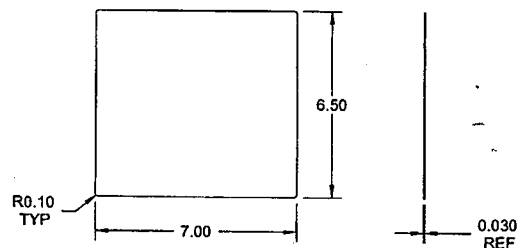
D4021-1 HANDLE PLATE



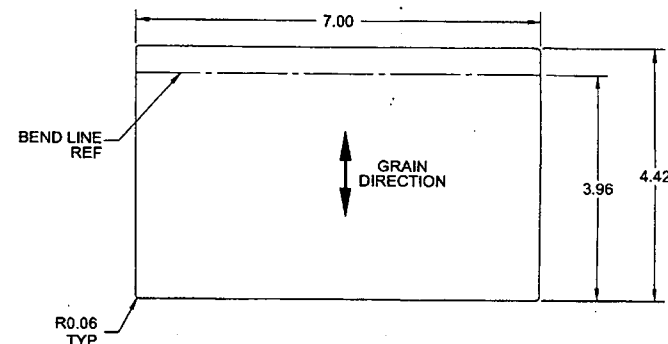
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE





D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
R 2010-04-14
NP

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -1: 0.18 lbs -3: 0.35 lbs
 -5: 0.14 lbs -11: 0.39 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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